

Date: Thursday, 1/17/2008 3:25:39 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: JACK SADDLE	
Job Number	: 36824		Part Number	: D2281	
Estimate Number	: 11177		Drawing Number	: D2281 REV G	
P.O. Number	:		Project Number	: N/A	
This Issue	: 1/17/2008	S.O. No. :	Drawing Revision	: G	
Prsht Rev.	: NC		Material	:	
First Issue	: / /	Type	Due Date	:	
Previous Run	: 35471		2/10/2008	Qty:	100 Um: Each
Written By	:				
Checked & Approved By	: <u>PG 080118</u>				
Comment	: Est Rev:A Removed from 9 Digit 05-12-02 JLM				
	Est: rev B 06.07.17 waterjet EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S14GA	304SS .080
		(2)
	Comment: Qty.: 0.1313 sf(s)/Unit Total : 13.1250 sf(s) 304SS .080 batch: <u>105112 HB 8-1-23</u>	
2.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET 1-Cut as per Dwg D2281 Dwg Rev: <u>G</u> HB 8-1-23 Prog Rev: <u>G</u>	(76) \$ No more mat.
	2-Deburr if necessary HB 8-1-23	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE HB 8-1-23	
4.0	QC8	SECOND CHECK
	Comment: SECOND CHECK S.080.09	(76) <i>coated</i>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: Deburr	<i>u/s Done at 8:00 AM 2022</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 5/02/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: JACK SADDLE

Job Number: 36824

Part Number: D2281

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Form as per D2281 using D2281-T2

SB

08/02/14

76

7.0 QC5 INSPECT WORK TO CURRENT STEP



counts

6 08/02/14 (476)

Comment: INSPECT WORK TO CURRENT STEP

8.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Done is

1/2/15

76

9.0 QC21 FINAL INSPECTION/W/O RELEASE



76

Comment: FINAL INSPECTION/W/O RELEASE

1/08/02/15

Job Completion



mi 2008/2/15

76

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	36824
Description: Jack Saddle	Part Number:	D2281
Inspection Dwg: D2281	Rev: G	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

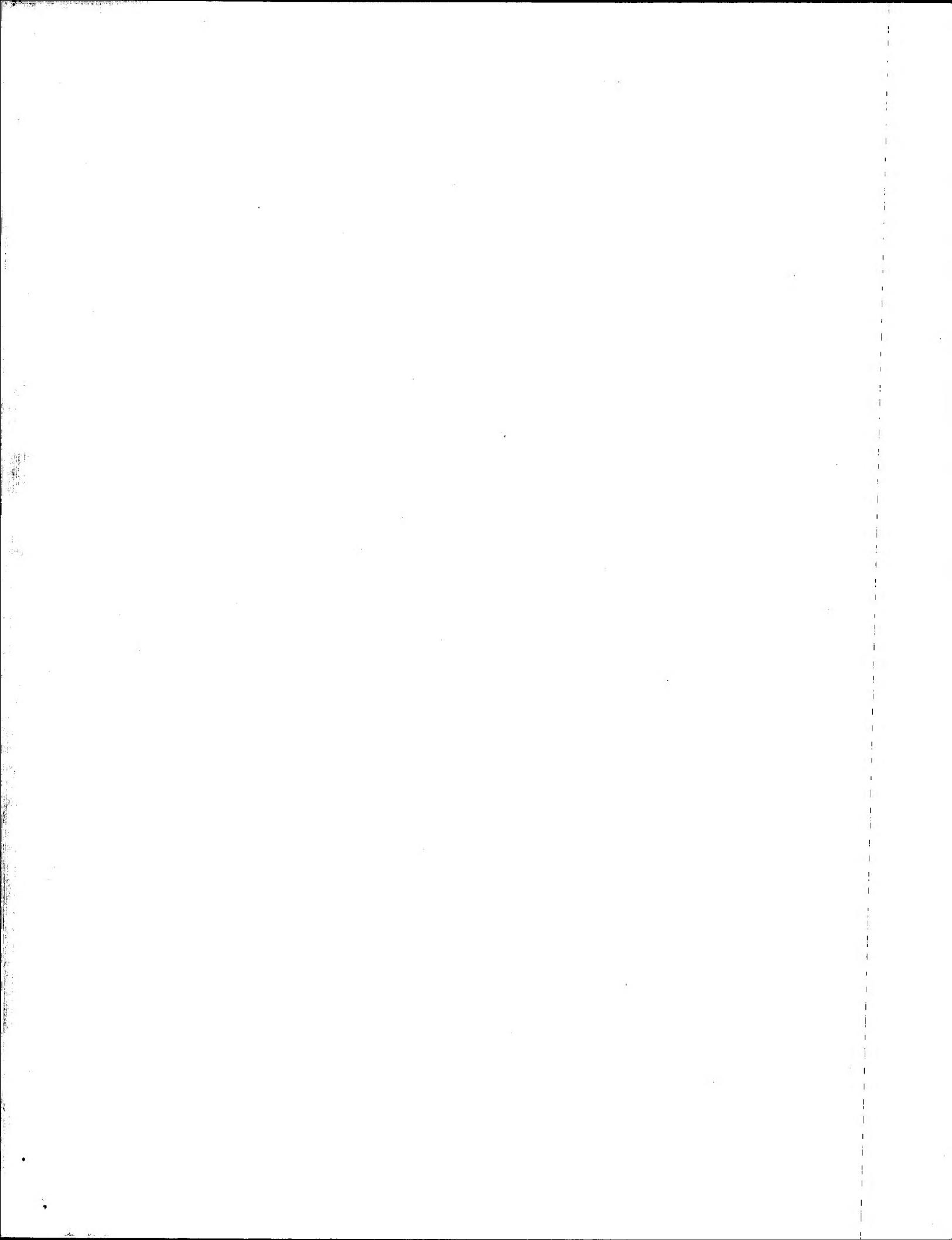
X First Article Prototype

Measured by:	LB
Date:	8-1-23

Audited by: *[Signature]*

Prototype Approval:	N/A
Date:	N/A

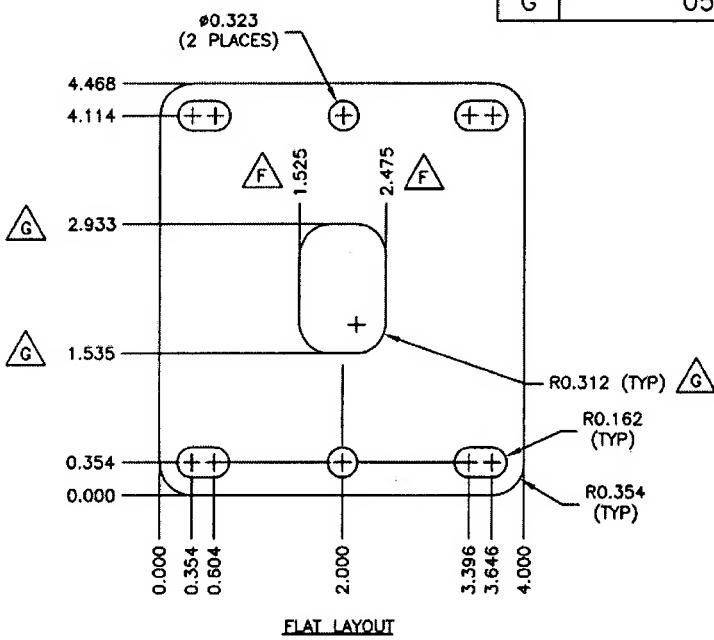
Rev	Date	Change	Revised by	Approved
A	06.09.08	New Issue	KJ/JLM	SM



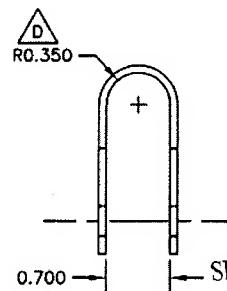
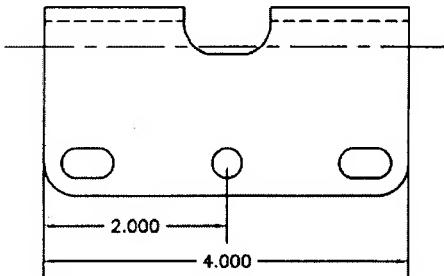
DART

DESIGN BW	DRAWN BY <i>FB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>IP</i>	APPROVED <i>WMS</i>	DRAWING NO. D2281	REV. G SHEET 1 OF 1
DATE 05.06.07		TITLE JACK SADDLE	SCALE 1:2
A	94.10.14	NEW ISSUE	
B	94.10.18	DIMENSION WAS 2.878	
C	94.11.04	ADD TOOLING NOTCH	
D	98.03.27	R0.350 WAS R0.280	
E	04.11.18	REMOVE TOOLING NOTCHES	
F	05.03.16	REDESIGN FLAT PATTERN	
G	05.06.07	REDESIGN FLAT PATTERN	

RELEASED
AB
05/08/11



FLAT LAYOUT



UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *36824*

D2281 JACK SADDLE

- 1) MATERIAL: 304/316 SS, 0.080 THICK (REF DART SPEC. M304S14GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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